

~~SHIP ASAP!~~ SHIP ASAP!

Work Order ID 58372 -1

May 4, 2010 3:17:15 PM



Item ID: D212-580-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Mirror Assembly

Start Date: 04/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date: 10-5-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2161

Rev B2

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile and create labels as per PPP D212-580-041 CHG003

5/10/15/14

to JG 10/05/18

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Assemble on Jig DT8065 as per Dwg D2161 2-Weld as per Dwg D2161 Identify as D2161-212 A/R SS ROD Batch: 10/08/10

10-5-14 21

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

Siobus 18

TV



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 58372

May 4, 2010 3:17:15 PM



Page 2

Item ID: D212-580-041

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① 10-05-18

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30AM

OVEN TEMPERATURE:

FINISH TIME:

320°F

=> 10/05/18

1 0

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

① BR 10-5-18.



| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |  | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 58372**

May 4, 2010 3:17:15 PM



Page 3

Item ID: D212-580-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Mirror Assembly

Start Date: 04/05/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

PO 10/01/18 (1)

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

5 10/01/18

(1)

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212--580-041 □ Location: \_\_\_\_\_ □ PPP Rev: 6

PO 10/01/18 (2)



| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |  | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 58372**

May 4, 2010 3:17:15 PM



Page 4

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Start Date: 04/05/2010 Start Qty: 6.00



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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18 AJ  
ME  
10-5-18



| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |  | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

May 4, 2010 3:17:19 PM

Page 1

Work Order ID: 58372

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly






Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item     | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-----------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| MS27039-1-08<br><br>Screw             | x4                     | Purchased     | No              |                     |                  | 100             | Each               | 1,474.000      | 4           |               |                |        |
|  |                        |               | <u>Location</u> |                     | <u>Loc Qty</u>   |                 | <u>Loc Code</u>    |                |             |               |                |        |
|  |                        |               | ST291           |                     | 1474             |                 |                    |                |             |               |                |        |
|  |                        |               | 110552          |                     | 44               |                 |                    |                |             |               |                |        |
|  |                        |               | 110835          |                     | 1430             |                 |                    |                |             |               |                |        |
| D2013-3<br><br>Mirror Bracket LH, 212 |                        | Manufactured  | No              |                     |                  | 110             | Each               | 0.0000         | 1           |               |                |        |
|  |                        |               | 58370 x1        |                     |                  |                 |                    |                |             |               |                |        |
| D2013-4<br><br>Mirror Bracket RH, 212 |                        | Manufactured  | No              |                     |                  | 110             | Each               | 0.0000         | 1           |               |                |        |
|  |                        |               | 58371 x1        |                     |                  |                 |                    |                |             |               |                |        |
| CCR264SS3-2<br><br>Rivet, Cherry    | x4                     | Purchased     | No              |                     |                  | 170             | Each               | 232.0000       | 4           |               |                |        |
|  |                        |               | <u>Location</u> |                     | <u>Loc Qty</u>   |                 | <u>Loc Code</u>    |                |             |               |                |        |
|  |                        |               | ST311           |                     | 232              |                 |                    |                |             |               |                |        |
|  |                        |               | 106578          |                     | 45               |                 |                    |                |             |               |                |        |
|  |                        |               | 108738          |                     | 87               |                 |                    |                |             |               |                |        |
|  |                        |               | 112314          |                     | 100              |                 |                    |                |             |               |                |        |
| D2011-103<br><br>8" Mirror          | x2                     | Manufactured  | No              |                     |                  | 170             | Each               | 13.0000        | 2           |               |                |        |
|  |                        |               | <u>Location</u> |                     | <u>Loc Qty</u>   |                 | <u>Loc Code</u>    |                |             |               |                |        |
|  |                        |               | ST226           |                     | 13               |                 |                    |                |             |               |                |        |
|  |                        |               | 52198           |                     | 13               |                 |                    |                |             |               |                |        |

M110830

EL 10-5-18

EL 10-5-18

M108738

EL 14-5-18

52198

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

May 4, 2010 3:17:19 PM

Page 2

Work Order ID: 58372

Parent Item: D212-580-041

Parent Item Name: Cargo Mirror Assembly

Comments: IPP Rev:H Removed D2013-3/-4 06-03-22 JLM

Start Date: 04/05/2010

Required Date: 13/05/2010

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|

D2037-101

Manufactured

No

~~170~~  
110

Each

10.0000

1



Arm



*12 10-5-18*

Location

Loc Qty

Loc Code

WA

10

52272

10

MS21059L3

*+2*

Purchased

No

170

Each

72.0000

2



Nut Plate



*10-14-18*

Location

Loc Qty

Loc Code

ST302

72

113749

10

114456

62

*114456*

May 4, 2010 3:17:19 PM

Shop Packet Print

Page 2

| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP |  | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      |  | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|--|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP |  | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |  |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |

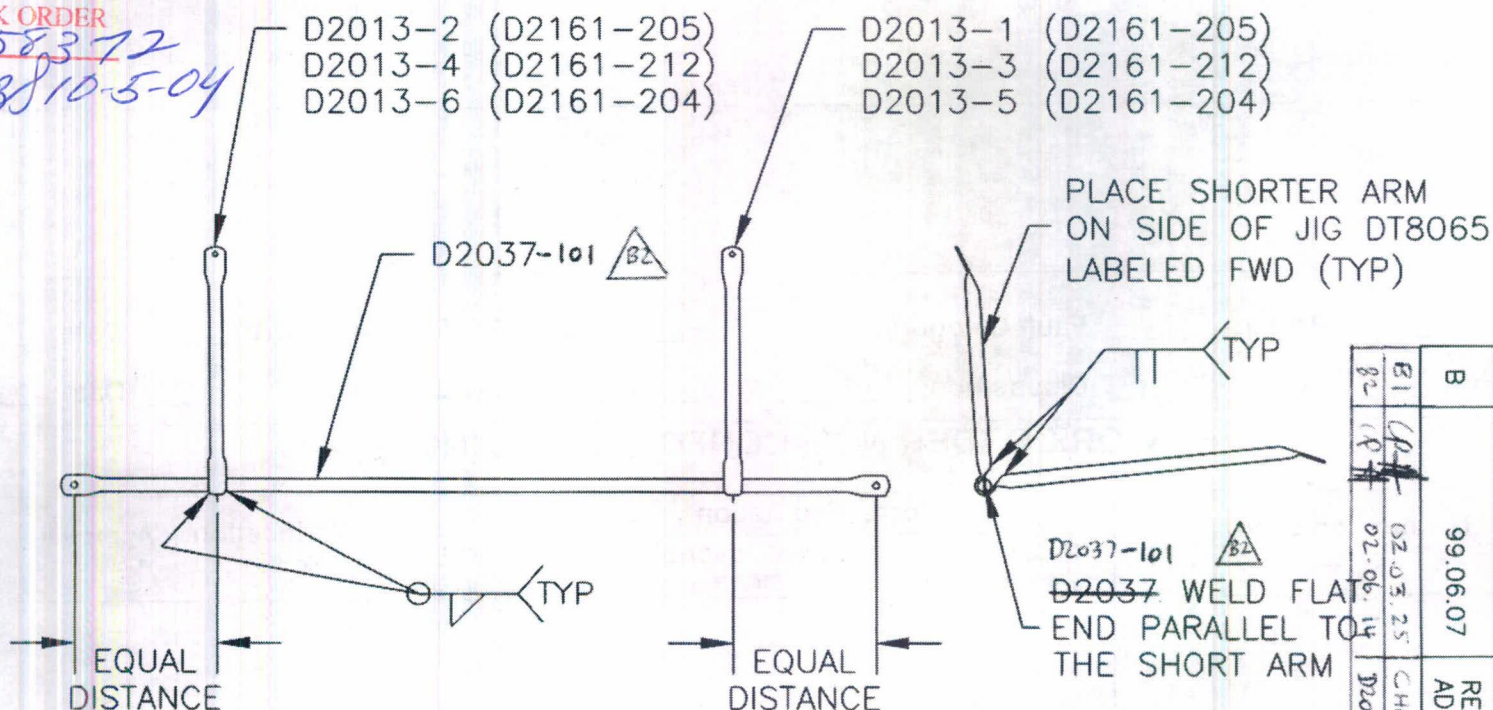
**NOTE:** Date & initial all entries



SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 58372  
BS10-5-04

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NOTE: WELD ASSEMBLY  
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~  
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER  
DART QSI 005 4.3 B1

DETAIL OF D2161-204  
DETAIL OF D2161-205  
DETAIL OF D2161-212

RELEASED  
KE 99.06.10

DART



| DESIGN  | JB       | DRAWN BY | DART AEROSPACE LTD<br>HAMKESBURY, ONTARIO, CANADA        | REV. B       |
|---------|----------|----------|--|--------------|
| CHECKED | JB       | APPROVED | DRAWING NO.  | SHEET 1 OF 1 |
| DATE    | 99.06.07 |          | D2161  | SCALE        |
|         |          |          | MIRROR BRACKET   | NTS          |
|         |          |          | NEW ISSUE  |              |
|         |          |          | REDRAWN FOR CLARITY<br>ADDED -204/-205/-212 DESIGNATIONS |              |
|         |          |          | CHANGE FINISH  |              |
|         |          |          | D2037-101 W  |              |
|         |          |          | 02.03.25   |              |
|         |          |          | 02.06.14   |              |
|         |          |          | 02.06.14   |              |
|         |          |          | 02.06.14   |              |



| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



## 4.0 WEIGHT AND BALANCE

| Installation             | Weight | LATERAL |         | LONGITUDINAL |             |
|--------------------------|--------|---------|---------|--------------|-------------|
|                          |        | Arm     | Moment  | Arm          | Moment      |
| D204-562-041             | 5.0 lb | 0 in    | 0 lb-in | 3.80 in      | 19.0 in-lb  |
| Dual Mirror Installation | 2.3 kg | 0 m     | 0 kg-m  | 0.10 m       | 0.23 m-kg   |
| D205-563-041             | 5.0 lb | 0 in    | 0 lb-in | 3.80 in      | 19.0 in-lb  |
| Dual Mirror Installation | 2.3 kg | 0 m     | 0 kg-m  | 0.10 m       | 0.23 m-kg   |
| D212-580-041             | 5.0 lb | 0 in    | 0 lb-in | -5.25 in     | -26.3 in-lb |
| Dual Mirror Installation | 2.3 kg | 0 m     | 0 kg-m  | -0.13 m      | -0.30 m-kg  |

## 5.0 PARTS LIST

| Qty<br>562<br>-041 | Qty<br>563<br>-041 | Qty<br>580<br>-041 | Part Number  | Description              |
|--------------------|--------------------|--------------------|--------------|--------------------------|
| X                  |                    |                    | D204-562-041 | DUAL MIRROR INSTALLATION |
|                    | X                  |                    | D205-563-041 | DUAL MIRROR INSTALLATION |
|                    |                    | X                  | D212-580-041 | DUAL MIRROR INSTALLATION |
| 2                  | 2                  | 2                  | D2011-103    | MIRROR                   |
| 1                  |                    |                    | D2161-204    | MIRROR BRACKET           |
|                    | 1                  |                    | D2161-205    | MIRROR BRACKET           |
|                    |                    | 1                  | D2161-212    | MIRROR BRACKET           |
| *2                 | *2                 | *2                 | D3015-3      | LOCKNUT                  |
| *2                 | *2                 | *2                 | AN960JD516   | WASHER                   |
|                    |                    | 4                  | CCR264SS-3-2 | RIVET, BLIND             |
|                    |                    | 2                  | MS21059L3    | NUTPLATE                 |
| 4                  | 4                  | 4                  | MS27039-1-08 | SCREW                    |

\* PARTS ARE INCLUDED WITH D2011-103 MIRROR



| W/O: |      |  | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |  |                    |    |      |     |                                     |                          |
|      |      |  |                    |    |      |     |                                     |                          |

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|------|------|--|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP |  | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |  |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |
|      |      |  |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries